

5/44

DART AEROSPACE LTD	Work Order:	24605
Description: Blade Fitting RH	Part Number:	D2742-2
Dwg: D2742 Rev. B1; DSK-050 Rev. A; D6103 Rev. A	Qty:	10
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveller Dwg not required	<i>[Signature]</i>	05.10.18	10																				
2	PG	Issue P/O: _____ Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9) 3.250" OD x 12.500" Long (+0.100/-0.030) per P/N D6103-001 Certificate of Conformity is required																							
3	RG	Receive and Inspect for transit damage Ensure Certificate of Conformity is attached																							
4	QC6	Inspect dimensions as per Dwg D6103																							
5	MS	Machine as per Folio FA099 (Note: Lathe work only!)																							
6	QC2	Inspect parts as they come off the CNC machine																							
7	QC8	Second inspection																							
8	MV	Machine as per Folio FA099 (Note: HAAS work!)																							
9	QC2	Inspect parts as they come off the CNC machine																							
10	QC8	Second inspection																							
11	FP	Chemical Conversion Coat as per QSI 005 4.1																							
12	FP	Powder Coat White (REF 4.3.5.1) as per QSI 005 4.3																							
13	QC3	Inspect Powder Coat																							
14	FP	Install ALS4-1032-225 Insert as per Dwg D2742 <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>4</td><td>ALS4-1032-225</td><td>Insert</td><td></td></tr><tr><td></td><td>or AKS4-1032-225</td><td></td><td></td></tr><tr><td></td><td>or ALS7-1032-225</td><td></td><td></td></tr><tr><td></td><td>or AKS7-1032-225</td><td></td><td></td></tr></table>	Qty	Part Number	Description	Batch	4	ALS4-1032-225	Insert			or AKS4-1032-225				or ALS7-1032-225				or AKS7-1032-225					
Qty	Part Number	Description	Batch																						
4	ALS4-1032-225	Insert																							
	or AKS4-1032-225																								
	or ALS7-1032-225																								
	or AKS7-1032-225																								
15	QC5	Inspect part 100% for completeness on the W/O																							
16	FP	Identify and Stock																							
17	AC	Cost / part <i>[Signature]</i>		05.10.20																					
18	DC	Close W/O Inspect Level 21																							

Rev	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	98.11.02	Blank size, inspection level added	KS	
C	99.02.02	Changed Procedure, Insert	DM	
D	00.11.01	Removed P/O for Powder Coat & for turning	EC	
E	00.11.17	Added picking DSK-050	EC	
F	02.05.07	Added turning sequence(remove DSK 050)	NG	
G	02.09.20	Re-format; Added P/O	KJ	
H	04.03.09	Added Steps 3 & 4	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
04.04.01 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24605
Description: Blade Fitting	Part Number:	D2742-2
Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

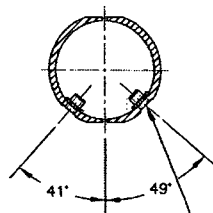
☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000					
	9.250	+/-0.010					
	Ø3.240	+0.005/-0.000					
	Ø3.125	+0.005/-0.000					
	Ø2.780	+0.005/-0.000					
	Ø2.450	+0.005/-0.000					
	0.125 x 45°	+/-0.010					
	0.125	+/-0.010					
	12.50	+0.030/-0.000					
HAAS	0.100 x 0.135	N/A	N/A				
	0.500	+0.005/-0.000					
	1.500	+/-0.005					
	11.46	+/-0.030					
	1.180	+/-0.005					
	3.150	+/-0.005					
	3.500	+/-0.005					
	Ø0.484	+0.005/-0.000					
	Ø0.508	+0.005/-0.000					
	1.000	+/-0.010					
	0.926	+/-0.010					
	0.500	+/-0.010					
	1.230	+/-0.010					
	0.125	+/-0.010					
	2.620	+/-0.010					
	0.297	+0.005/-0.000					
	Ø0.430 x 0.045	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

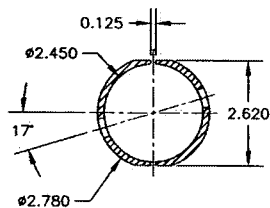
Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	<i>[Signature]</i>

SECTION B-B



Ø0.297
C'BORE Ø0.430 x 0.045"
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

SECTION A-A

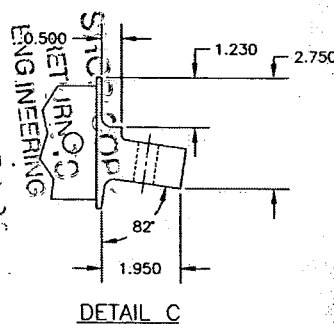


EFFECTIVE	DEOs
9147	

WORK ORDER
NO. 24605

SUBJECT TO A
WITHOUT NOTICE

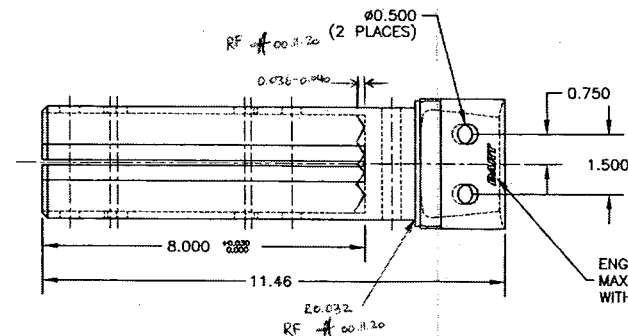
UNCONTROLLABLE



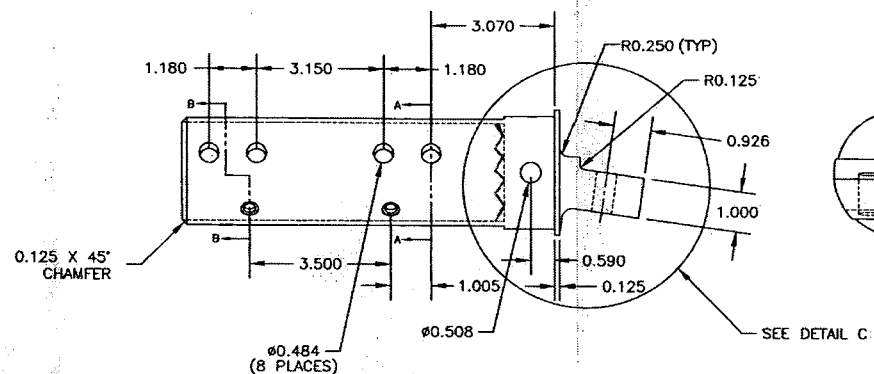
DETAIL C

GENERAL NOTES

MATERIAL: 7075-T651 (Q0-A-200/11 OR Q0-A-225/9)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



ENGRAVE DART LOGO TO
MAX DEPTH OF 0.015
WITH MIN RAD 0.250



D2742-1 SHOWN (D2742-2 OPPOSITE)

RELEASED
98.11.03 DS

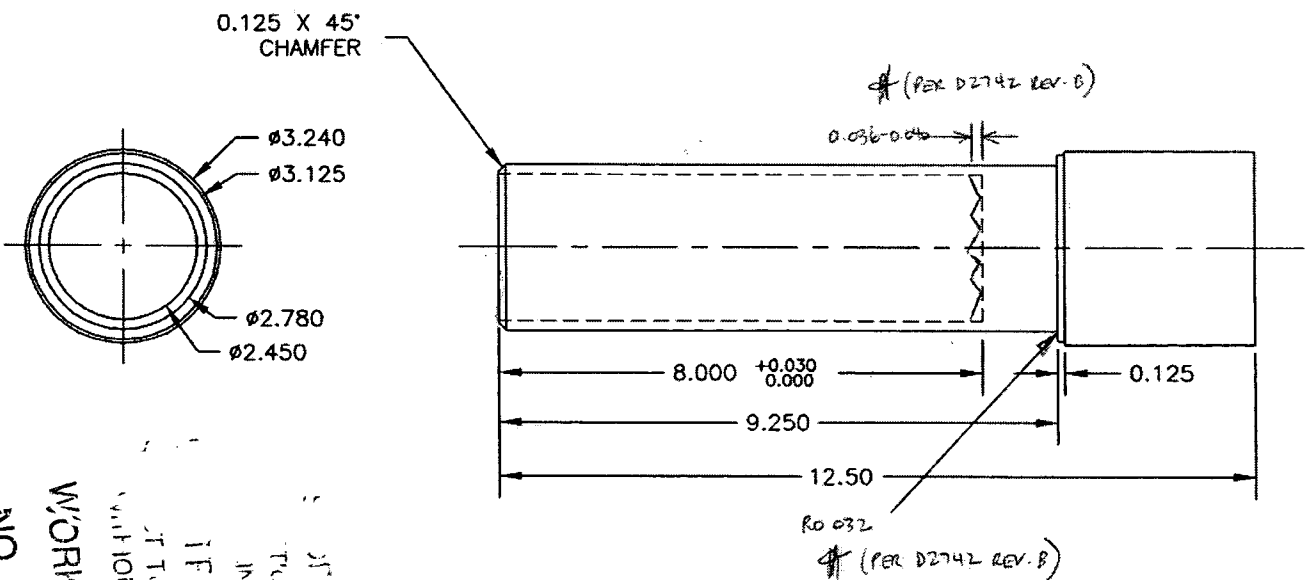


B	98.09.01	ADD INSERTS, AS MANUFACTURED
A	98.04.16	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2742
DATE	TITLE	SCALE
98.09.01	BLADE FITTING	1:3

DART

DESIGN	05	DRAWN BY	KE	DART AEROSPACE LTD
CHECKED	RF	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.07	DRAWING NO.	DSK-050	REV. A
		TITLE	BLADE FITTING TURNING DETAILS	SHEET 1 OF 1
A	98.12.07	NEW ISSUE		SCALE 1:3

RELEASED
98-02-03 DS



GENERAL NOTES

MATERIAL: 7075-T651 (QQ-A-200/11 OR QQ-A-225/9)
FINISH: NONE
BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

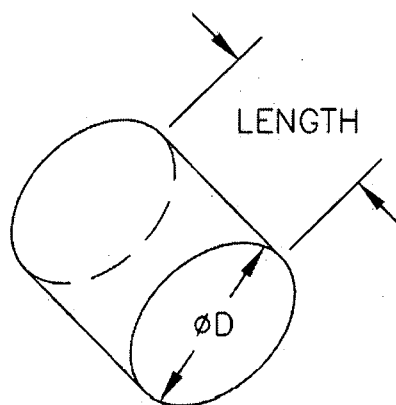
IF CO
TURN T
INTE
ST TO
WITH
NO. 24605
WORK ORDER



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. A SHEET 1 OF 1
DATE 01.04.10		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01 04 23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50

STOP COPY
RETURN TO
ENGINEERING
IF YOU
RECEIVE
WITHOUT NOTICE

WORK ORDER
24605

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
11:00 am

Work Order No	: 0024605	Department Code:	
Project Name	: D2742-2	Burden Flags	: NNNNNNNN
Project For	: WK544	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2742-2	Invoice Number	:
Description	: Blade Fitting, RH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-18-05		
Est Finish Date	: 11-05-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00